

EUROPEAN PATENT OFFICE

Patent Abstracts of Japan

PUBLICATION NUMBER : 03268884
PUBLICATION DATE : 29-11-91

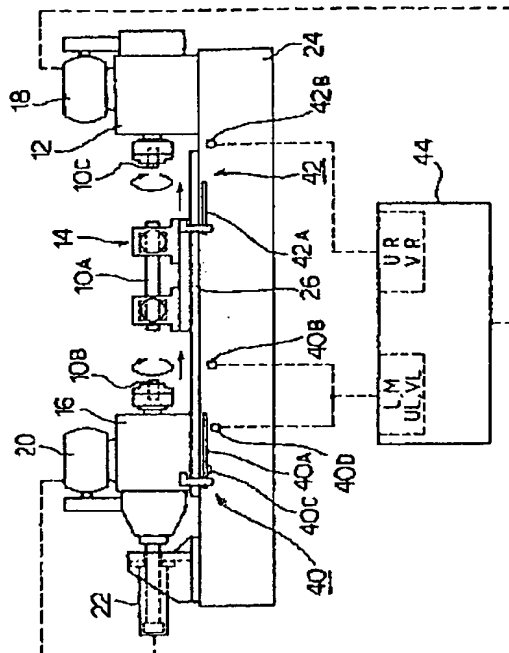
APPLICATION DATE : 15-03-90
APPLICATION NUMBER : 02062734

APPLICANT : TOSHIBA MACH CO LTD;

INVENTOR : NODA SABURO;

INT.CL. : B23K 20/12

TITLE : METHOD AND DEVICE FOR
INSTRUMENTATION CONTROL OF
DUPLEX DRIVING TYPE FRICTION
WELDING DEVICE



ABSTRACT : PURPOSE: To prevent the deviation of near margins of both pressure welding parts by deriving the cooling correction quantity of a product and setting the product correction length, executing the instrumentation control of the near margins of both the pressure welding parts among three working pieces and allowing the product working length to conform to the product correction length.

CONSTITUTION: The friction welding device is constituted of a fixed head 12 for holding an outside working piece 10C so as to be freely rotatable, a clamp 14 for holding an intermediate working piece 10A so as to be movable, and a slide head 16 for holding an outside working piece 10B pressure-welded to the other end of the intermediate working piece 10A so as to be freely rotatable, and also, allowing pressing force to work on the fixed head 12 side. At the time of working, a process for calculating the cooling correction quantity extending from the time of working completion of a product to cooling to set in advance the product correction length, a process for measuring stock length of three working pieces 10B, 10A and 10C, and a control process for executing the instrumentation control of the respective near margins in both the pressure welding parts among three working pieces 10B, 10A and 10C, and also, allowing the product working length to conform to the product correction length are provided, therefore, it does not occur that the near margins of both the pressure welding parts among three working pieces for molding a product are deviated.

COPYRIGHT: (C)1991,JPO&Japio

272-1042